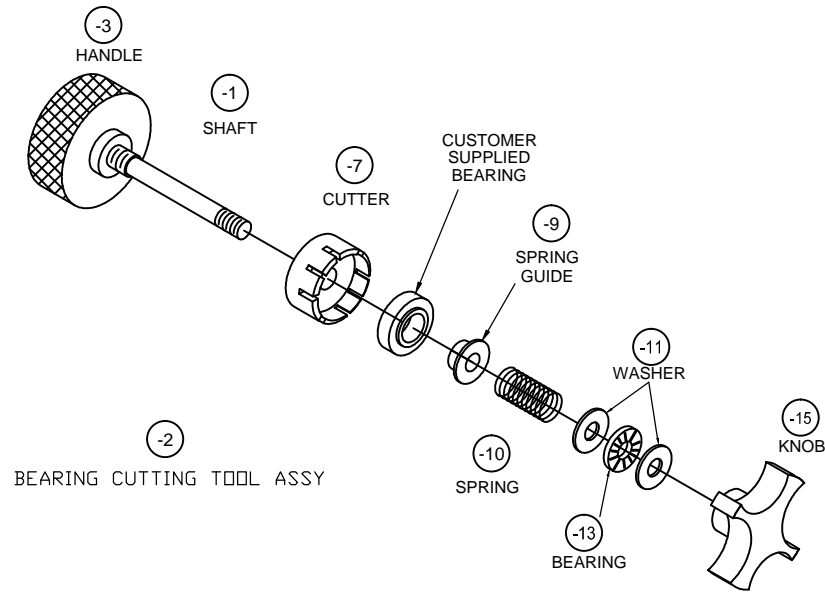


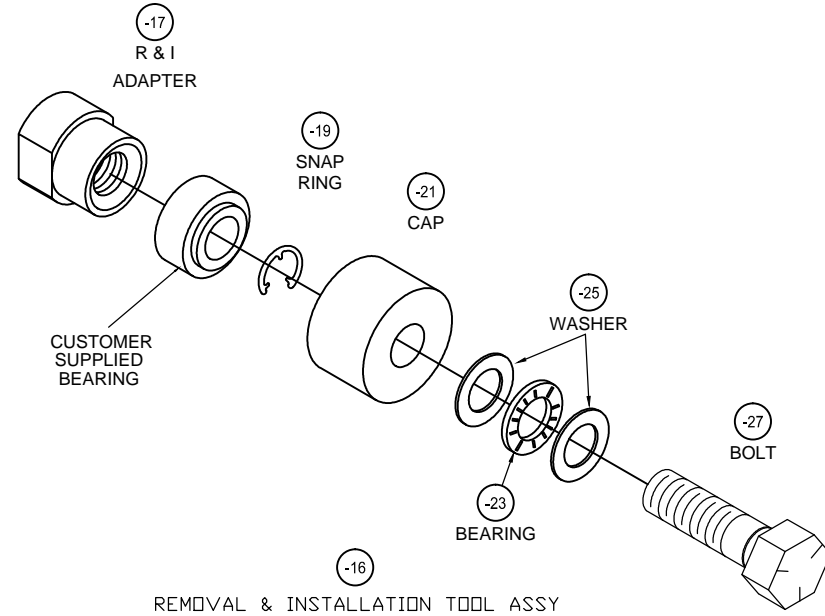
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NOTE:
BEARING #206-033-509-3, Y-27352-1-1, ASTRO-NHBY6V17

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
	1		-1		SHAFT	STRESS PROOF	Ø3/4 x 4	2
	1		-2	1	BEARING CUTTER TOOL ASSY			1
	1		-3		HANDLE	6061 T6	Ø2 x 3/4	2
	1		-7		CUTTER	01	Ø1 x 5/8	3
	1		-9		SPRING GUIDE	STRESS PROOF	Ø5/8 x 5/16	3
	1	B/O	-10		SPRING	-	5/16 x 2 (EUGENE FASTNER #16)	1
	2	B/O	-11		WASHER	-	TRA-411 (APPLIED INDUSTRIAL)	1
	1	B/O	-13		BEARING	-	NTA-411 (APPLIED INDUSTRIAL)	1
	1	B/O	-15		KNOB	-	DK-54 (REID TOOL)	1
	1		-16	1	REMOVAL & INSTALLATION TOOL ASSY			1
	1		-17		R&I ADAPTER	STRESS PROOF	Ø1 x 1-1/4	4
	1	B/O	-19		RETAINING RING	-	Ø3/8 EXTERNAL E-37	1
	1		-21		CAP	6061 T6	Ø1-1/4 x 1	4
	1	B/O	-23		BEARING	-	NTA-613 (APPLIED INDUSTRIAL)	1
	2	B/O	-25		WASHER	-	TRA-613 (APPLIED INDUSTRIAL)	1
	1		-27		BOLT	GRADE 5	3/8-24 UNF x 2-3/4 MODIFY	4

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-7 RADIAL ANGLE INCREASED FROM 2° TO 5° TO IMPROVE OPERATION.	2/19/04		
2	CH'D -27 GROOVE FOR RETAINING RING.	9/21/06		
3	CH'D -7 PREGRIND TOLERANCE FROM .910 +.005 -.002.	1/2/08	WP	G.E.
4	ADDED AN 8° HOOK TO CUTTING TEETH, WAS STRAIGHT WITH NO HOOK.	1/29/08	WP	DW
4A	CH'D TITLEBLOCK & REVISION BLOCK, CORRECTED VIEWS & LABELED ALL SECTION VIEWS, ADDED DETAIL A P/N -1 TO CLARIFY TAPER.	9/29/09	RJC	RW
4B	CH'D -17 REMOVED Ø.700 DIMENSION.	5/10/13	CFS	GE



RED BARN MACHINE

TITLE
BEARING CUTTER

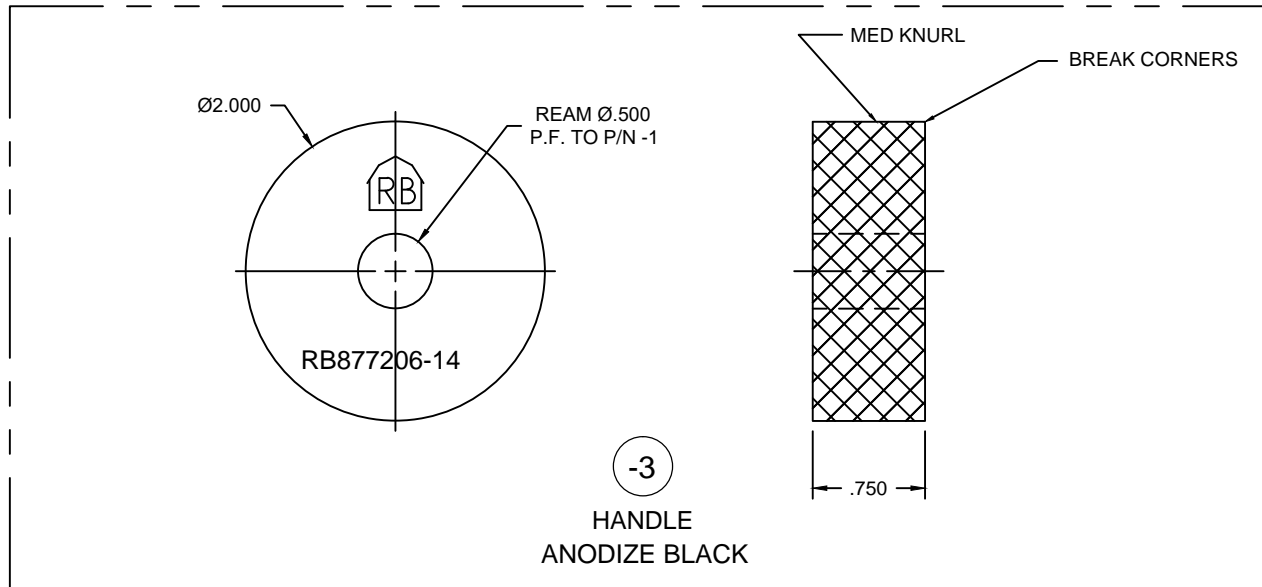
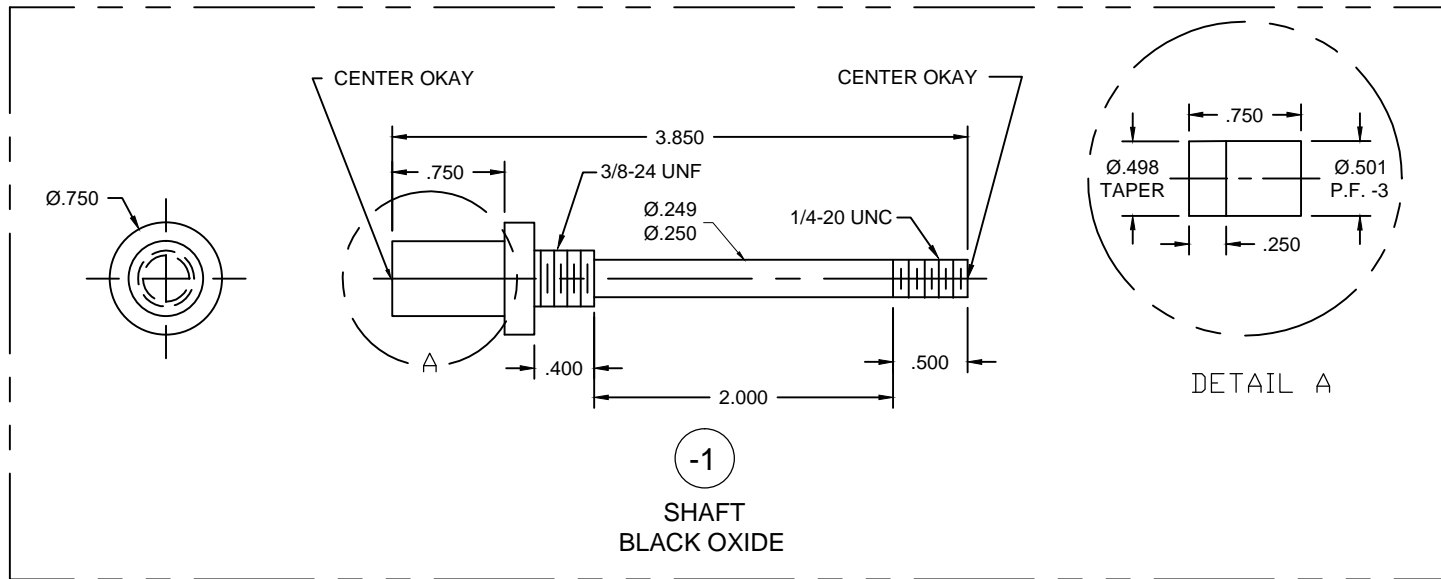
DWG NO. RB877206-14

REV
4B

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: COLE	
TOLERANCES ON:		APPROVED	
DECIMALS		HEAT TREAT	
.XXX ± .005		FINISH SPEC	
.XX ± .01		USED ON MODEL	
.X ± .1		BELL	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		SCALE NTS	
DATE 6-28-01		SHEET 1 of 4	

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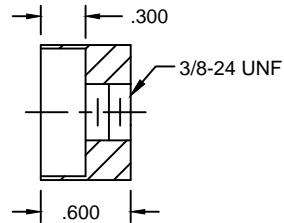
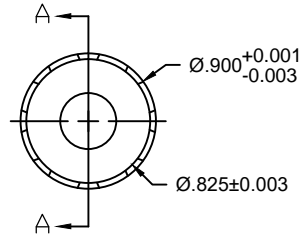
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
4A	CH'D TITLEBLOCK & REVISION BLOCK, CORRECTED VIEWS & LABELED ALL SECTION VIEWS, ADDED DETAIL A P/N -1 TO CLARIFY TAPER.	9/29/09	RJC
			RW



RED BARN MACHINE	
TITLE BEARING CUTTER	
DWG NO. RB877206-14-1 & -3	REV 4B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: COLE
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	APPROVED
FRACTIONS ± 1/32 ANGLES ± 5°	HEAT TREAT
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	FINISH SPEC SEE PART
SCALE NTS	USED ON MODEL BELL
DATE 6-28-01	SHEET 2 of 4

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-7 RADIAL ANGLE INCREASED FROM 2° TO 5° TO IMPROVE OPERATION.	2/19/04		
3	CH'D -7 PREGRIND TOLERANCE FROM .910 +.005 -.002.	1/2/08	WP	G.E.
4	ADDED AN 8° HOOK TO CUTTING TEETH, WAS STRAIGHT WITH NO HOOK.	1/29/08	WP	DW



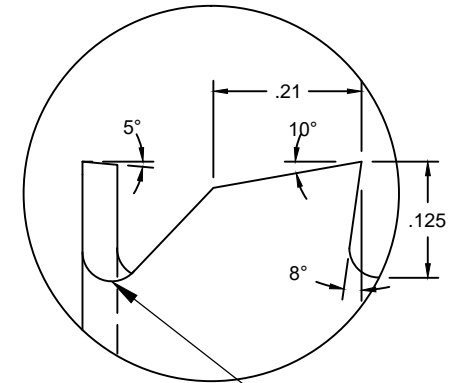
SECTION A-A

MACHINE TO .920 \pm .005
GRIND TO SIZE
AFTER HEAT TREAT

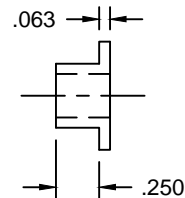
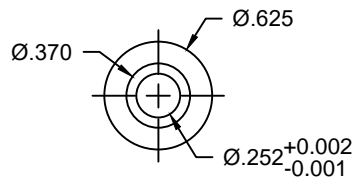
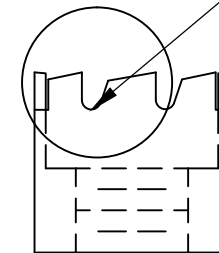
-7

CUTTER
8 TEETH

HEAT TREAT: 50-60 Rc
NO OXIDE COATING



ROUND
GULLET
OKAY



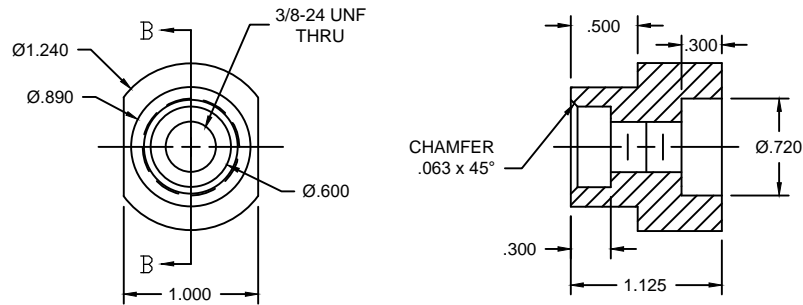
-9

SPRING GUIDE
BLACK OXIDE

RED BARN MACHINE	
TITLE BEARING CUTTER	
DWG NO. RB877206-14-7 & -9	REV 4B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX \pm .005 .XX \pm .01 .X \pm .1	
FRACTIONS \pm 1/32 ANGLES \pm 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 6-28-01
SHEET 3 of 4	
DRAWN BY: COLE	
APPROVED	
HEAT TREAT SEE PART	
FINISH SPEC SEE PART	
USED ON MODEL BELL	

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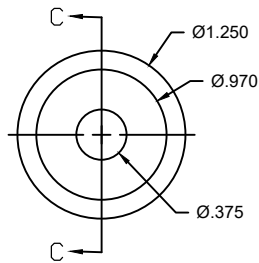
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	CH'D -27 GROOVE FOR RETAINING RING.	9/21/06		
4B	CH'D -17 REMOVED Ø.700 DIMENSION.	5/10/13	CFS	GE



-17

ADAPTER R&I
BLACK OXIDE

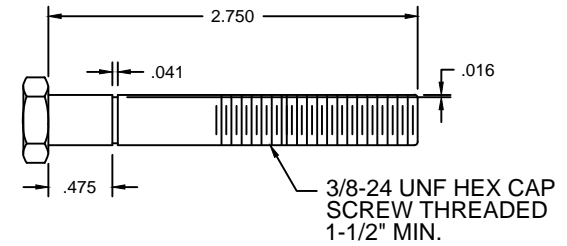
SECTION B-B



-21

CAP
ANODIZE BLACK

SECTION C-C



-27

BOLT
BLACK OXIDE

RED BARN MACHINE	
TITLE BEARING CUTTER	
DWG NO. RB877206-14-17 thru -27	REV 4B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1	
FRACTIONS ± 1/32 ANGLES ± .5° UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: COLE APPROVED HEAT TREAT FINISH SPEC SEE PART USED ON MODEL BELL	
SCALE NTS	DATE 6-28-01
SHEET 4 of 4	